

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017989**Date Inspected:** 10-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG TRIAL ASSEMBLY YARD

**WELDING:****Segment 11BE ~ 11CE**

This QA Inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-010; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Plate Transverse CJP Weld. The Welding Repair Report (WRR) was B-WR16740. ZPMC QC is identified as Mr. An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

**Segment 11DW ~ 11EW**

This QA Inspector observed ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc

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## WELDING INSPECTION REPORT

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Welding (SMAW), weld joint identified as OBW11C-007; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate CJP Weld. ZPMC QC is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

### Segment 11DW ~ 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11C-009; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate CJP Weld. ZPMC QC is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-P-2214-TC-U4b-FCM-1.

### Segment # 11DE ~ 11EE

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11A-006; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached photo for further details.

### Segment # 11DE ~ 11EE

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP559-001-053; located On Orthotropic Box Girder (OBG) T-Rib to T-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

### Segment # 11DW ~ 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP682-001-019; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-3213-B-U3b.

### Cross Beam # 15

This QA Inspector observed ZPMC qualified welding personnel identified as 052930 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB202A-015-016; located On Orthotropic Box Girder (OBG) Side Plate to Bottom Plate Corner Joint; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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